Work Order ID 71326

Tuesday, June 28, 2011 10:06:23 AM

Item ID: D3391-025 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 6/28/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 7/27/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** UMF **Date:** 11-06-28 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3391	Rev H/ DEO								
100	MORI SEIKI CNC LATHE LARGE	0.00				1	Ø		
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	Turn as per Folio FA599 Rev: H & Dwg D3391 Rev: AA								
	scribe batch # on fwd end at 90 degree					MML 11/06/29			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				1	Ø		
Quality Control									
111	QC8- Inspect parts - second check	0.00				1			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71326

Tuesday, June 28, 2011 10:06:23 AM

Item ID: D3391-025 **Accept** **Setup Start**

Revision ID:

Item Name: Aft Tube Assembly **Stop**

Start Date: 6/28/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 7/27/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
HAAS 1	HAAS CNC VERTICAL MACHINING #1								
HAAS CNC vertical machine #1	**Memo** 1-Machine as per Folio FA 599 Rev: ~~AA~~ & Dwg D3391 Rev: ~~H~~ 2-Deburr	0.00	CRL 11/07/04			1	~~0~~		
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00	CRL 11/07/04			1	~~0~~		
Quality Control									
140	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00	B.A 11/07/04			1	0		
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170	QC5- Inspect part completeness to step on W/O	0.00				1	0	BE 11/07/04	
QC	**Memo**	0.00							
Quality Control	H. 4.15"								

DP 11-7-4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .
*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

DD 11-7-4

DE 11/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71326

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Start Date: 6/28/2011 **Start Qty:** 1.00 **Cust Item ID:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
200	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

11/07/04

11/07/04

11-7-4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: M116677 exp. date : 11/08. cure time 12hrs as per QSI0015								11/07/04
230	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00				1	0		4/07/03
HandFinish	~~Memo~~	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 1:30								
M 117745									
250	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
260	HandFinishing	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 M117516 Sikaflex expiry date: 15/01								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00							
280	Identify as per dwg & Stock Location: W/O	0.00	D412-742-043/B71323						
Packaging						1	ø	11/07/06	
Packaging	**Memo**	0.00							
290	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

11/7/11

MF 11-07-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Tuesday, June 28, 2011 10:06:20 AM

Work Order ID: 71326

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/28/2011 **Required Date:** 7/27/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090		Manufactured	No		56572	100	Each	0.0000	1	1	1	11/06/28	
ALUMINUM EXTRUSION													
D3670-4-200		Manufactured	No			230	Each	38.0000	4	4		11/07/04	
SPACER													
				Location		**Loc Qty**		**Loc Code**					
				LG		38							
					70822	38				4			
D2646		Manufactured	No			270	Each	74.0000	1	1		11/07/06	
Aft Cap													
				Location		**Loc Qty**		**Loc Code**					
				FP004		60							
					68280	60							
				FP006		14							
					62678	14				X1			
D3537-1		Manufactured	No			270	Each	41.0000	1	1		11/07/06	
Wearpad													
				Location		**Loc Qty**		**Loc Code**					
				FP017		41							
					69278	34				X1			
					69817	7							

Dart Aerospace Ltd

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Picklist Print

Tuesday, June 28, 2011 10:06:20 AM

Work Order ID: 71326

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/28/2011 **Required Date:** 7/27/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3537-7	Manufactured	No	270	Each	4.0000	1	1	
Wearpad								HL 11/07/06

Location	Loc Qty	Loc Code	
FP019	4		
69320	4		V1

D3553-1	Manufactured	No	270	Each	8.0000	1	1	
Gasket								HL 11/07/06

Location	Loc Qty	Loc Code	
FP013	8		
56568	8		V1

D3553-3	Manufactured	No	270	Each	32.0000	1	1	
Gasket								HL 11/07/06

Location	Loc Qty	Loc Code	
FP	20		
31631	20		
FP013	12		
53480	12		V1

D3672-1	Manufactured	No	270	Each	1,122.000	2	2	
Phenolic Washer								HL 11/07/06

Location	Loc Qty	Loc Code	
ST074	1096		
64177	596		V2
66821	500		
ST077	26		
52505	26		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Tuesday, June 28, 2011 10:06:20 AM

Work Order ID: 71326

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/28/2011 **Required Date:** 7/27/2011

Start Qty: 1.00 **Required Qty:** 1.00

ALS4-1032-130	Purchased	No	260	Each	1,122.000	14	14	
Insert								11/07/06

Location		Loc Qty	Loc Code	
ST281		8		
	117331	8		
ST282		1114		
	117717	1114		X14

ALS4-1032-225	Purchased	No	270	Each	666.0000	12	12	
Insert								11/07/06

Location		Loc Qty	Loc Code	
ST282		666		
	110768	213		
	117717	453		X12

AN3C4A	Purchased	No	270	Each	2,162.000	6	6	
BOLT								11/07/06

Location		Loc Qty	Loc Code	
ST350		2162		
	117313	2		
	117688	776		
	117795	500		
	117872	22		
	118012	500		
	118112	362		X6

Dart Aerospace Ltd

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Picklist Print

Tuesday, June 28, 2011 10:06:21 AM

Work Order ID: 71326

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/28/2011 **Required Date:** 7/27/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C5A		Purchased	No	270	Each	1,385.000	4	4	
Bolt									

Location		Loc Qty	Loc Code
FP-A		7	
	115835	7	
ST350		1378	
	116419	28	
	116549	54	
	117343	500	
	117764	300	
	117872	496	

AN960C10L	NAS1149C0332R	Purchased	No	270	Each	0.0000	10	10	
washer									

M117466 (x10) 11/07/06

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	91326
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 **Rev:** H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	MML-02
3.500	+/-0.010	3.502	✓		vern	JF-01
88.93	+/-0.030	88.940	✓		tape	MML-02
Ø3.200	+/-0.010	3.200	✓		mic.	CNC-05
88.93	+/-0.030	88.940	✓		tape	MML-02
Ø3.750	+/-0.010	3.746	✓		mic	CNC-05
30° x 160" chamfer	+/-0.010	30° x 60"	✓		vern	JF-01

Measured by:	MML / [illegible]	**Date:**	11/06/28
Audited by:	[illegible]	**Date:**	11/6/28

HAAS Section						
1.526	+0.000/-0.030	1.570	—		Vern	ML-7
7.500	+/-0.010	7.500	—		Vern	CNC-02
27.750	+/-0.010	27.750	—		M-tape	ML-2
31.750	+/-0.010	31.750	—		"	"
35.250	+/-0.010	35.250	—		"	"
3.300	+/-0.010	3.301	—		Vern	ML-7
0.200	+/-0.010	.200	—		"	"
3.520	+/-0.010	3.523	—		"	"
0.687	+0.010/-0.000	.687	—		"	"
R0.062	+/-0.010	R.062	—		R-G	
Ø0.484	+0.005/-0.001	Ø.488	—		Vern	ML-7

Measured by:	[illegible]	**Date:**	11/07/04
Audited by:	B.A	**Date:**	11/07/04

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

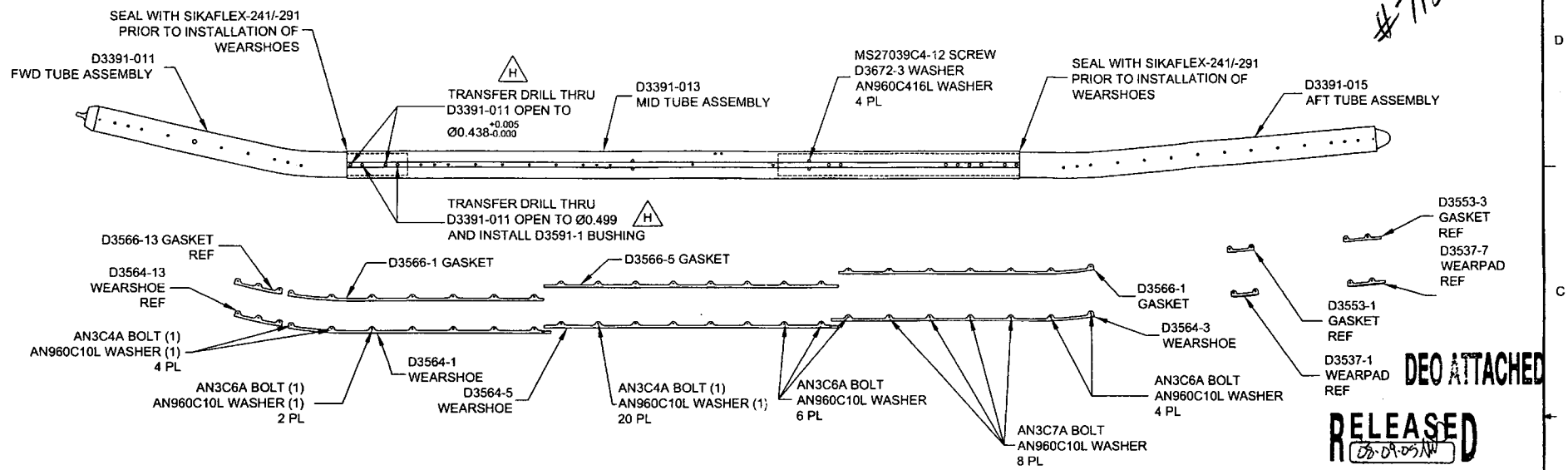
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO.RevE

#71326



DEO ATTACHED

RELEASED 08-09-05 AW

D3391-041 ASSEMBLY

REV.	DESCRIPTION	BY	DATE
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. D3391 — REV. H — SHEET 1 OF 8
MFG. APPR.		
APPROVED		TITLE: 412 FLOAT SKIDTUBE — SCALE: NTS
DE APPR.		
DATE	08.08.20	

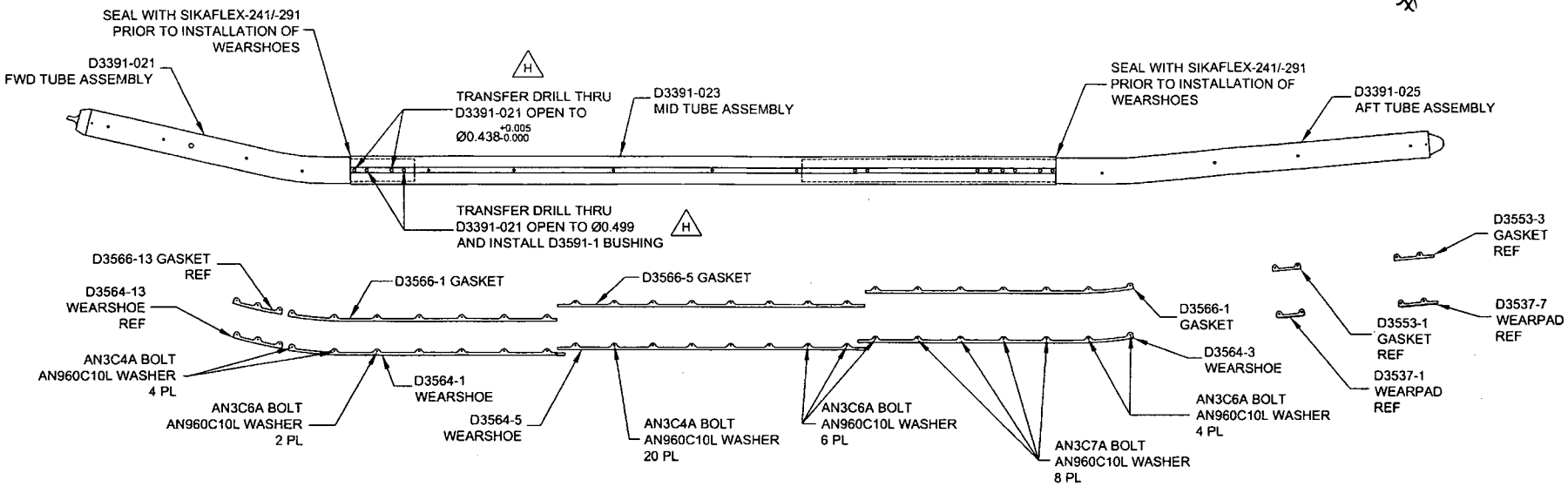
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

H

GENERAL NOTES

1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.



D3391-043 ASSEMBLY

#71324

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

H

GENERAL NOTES

1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

RELEASED 08-09-05

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 2 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	

Dart Aerospace Ltd

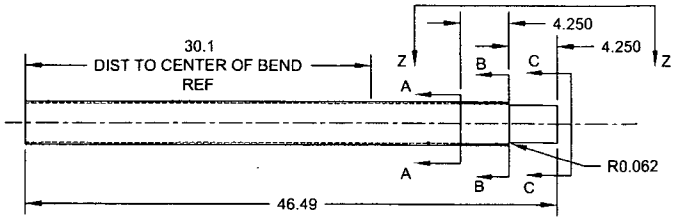
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

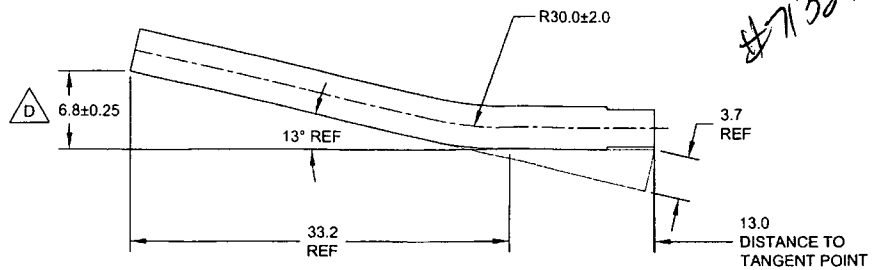
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

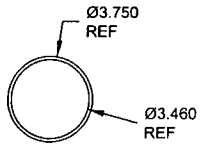


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

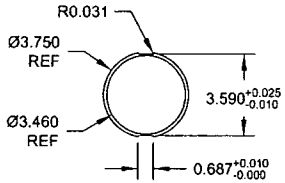


D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

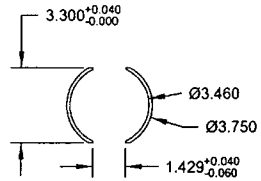
#71326



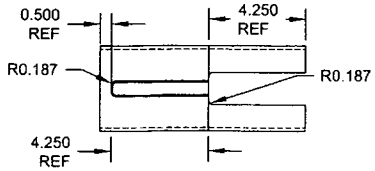
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED

RELEASED 08.09.05 NW

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20		

Dart Aerospace Ltd

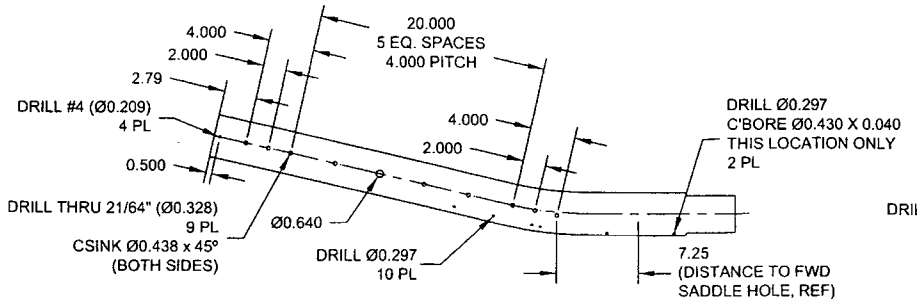
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

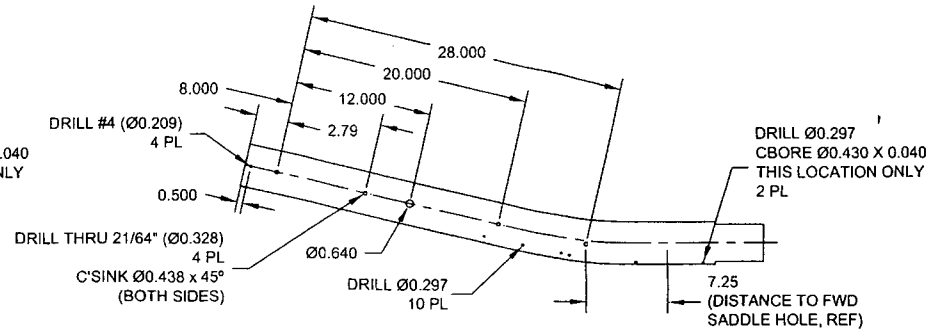
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

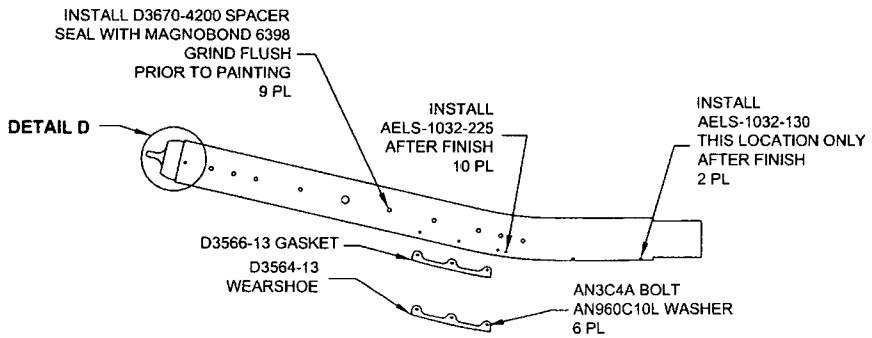


D3391-011 DRILLING DETAIL

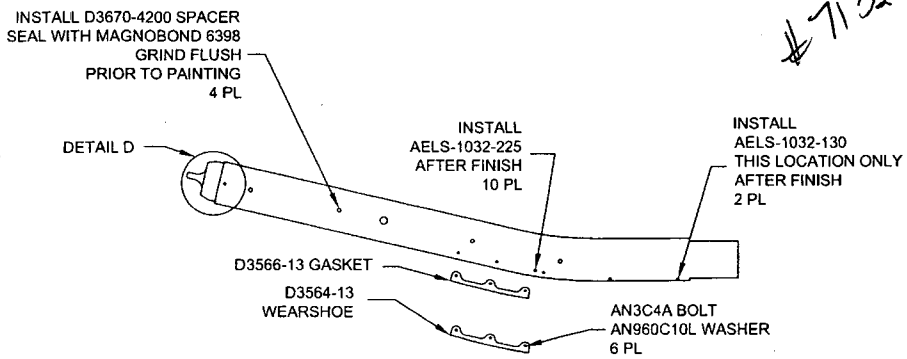


D3391-021 DRILLING DETAIL

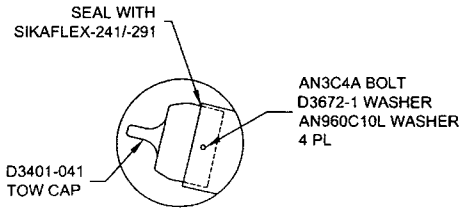
#71326



D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL



DETAIL D
SCALE 2X

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

DEO ATTACHED

RELEASED 08.09.05 NW

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. D3391 — REV. H — SHEET 4 OF 8
MFG. APPR.		
APPROVED		TITLE: 412 FLOAT SKIDTUBE — SCALE: NTS
DE APPR.		
DATE	08.08.20	

Dart Aerospace Ltd

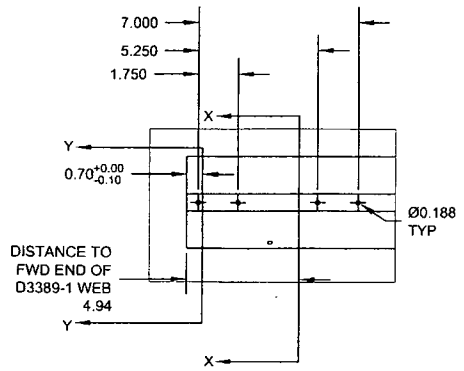
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

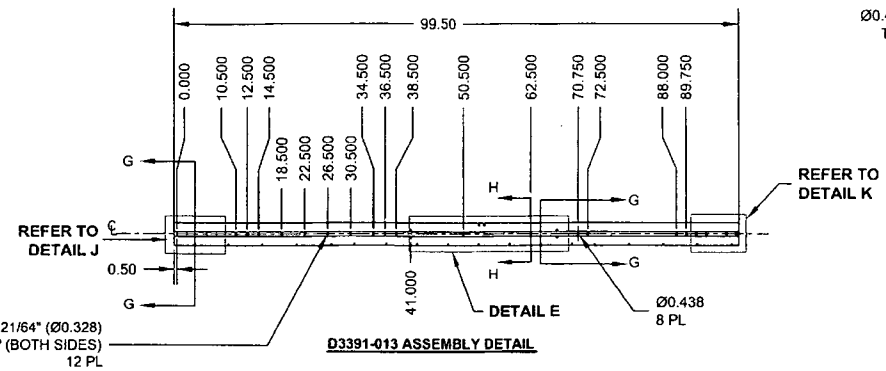
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

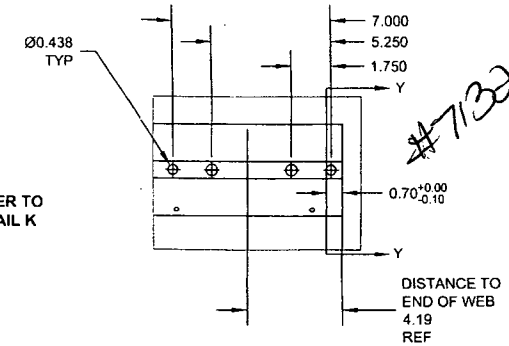
NOTE: Date & initial all entries



DETAIL J
SCALE 4X



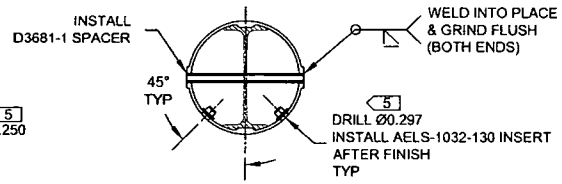
D3391-013 ASSEMBLY DETAIL



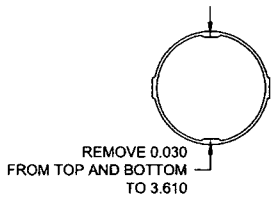
DETAIL K
SCALE 4X

#71326

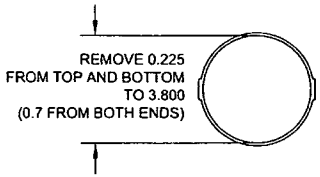
SECTION G-G
SCALE 5X



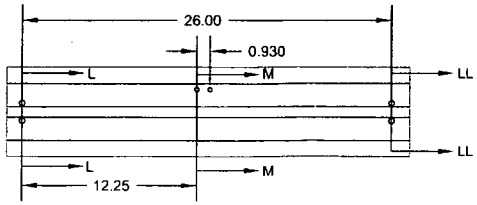
SECTION H-H 12 PL
SCALE 5X



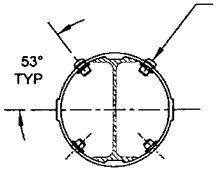
SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

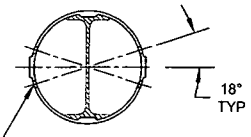


DETAIL E
SCALE NONE



DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL

SECTION M-M
SCALE 5X

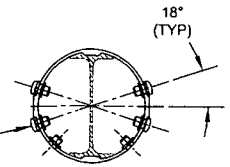


DRILL Ø0.250
4 PL

SECTION LL-LL
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
3) WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED 08-08-2020

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 5 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	

Dart Aerospace Ltd

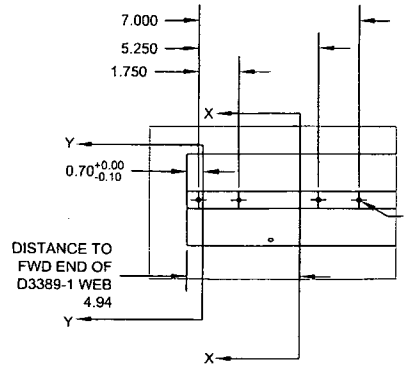
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

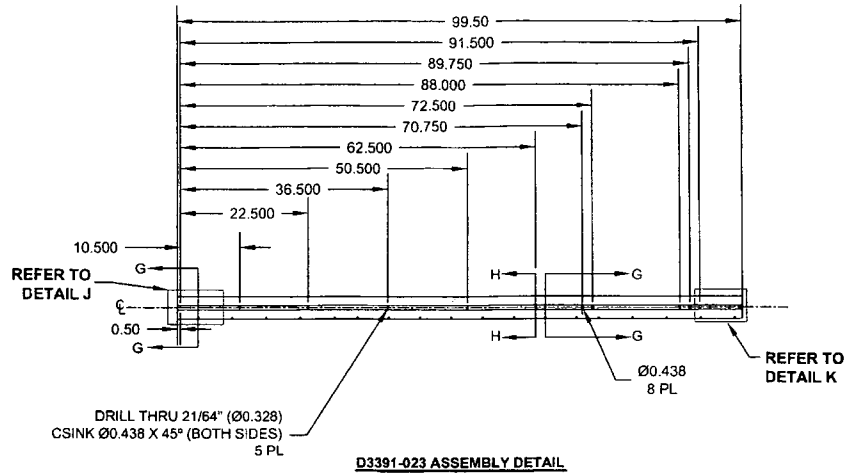
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

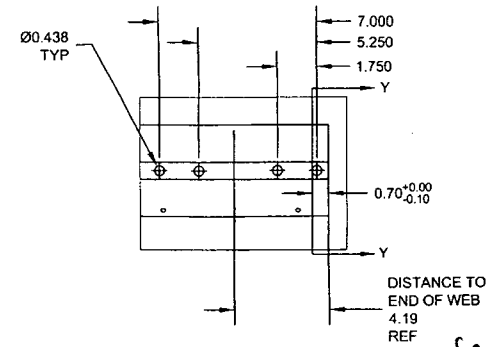
NOTE: Date & initial all entries



DETAIL J
SCALE 4X

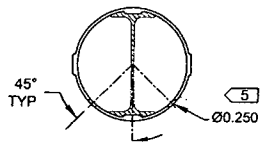


D3391-023 ASSEMBLY DETAIL

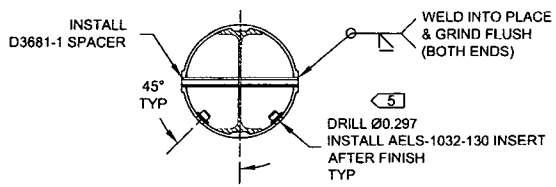


DETAIL K
SCALE 4X

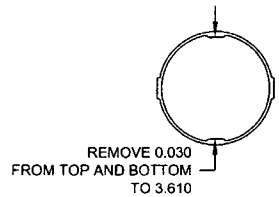
#71326



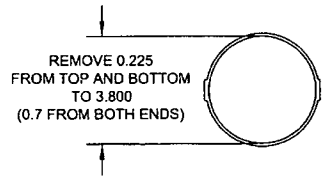
SECTION G-G
SCALE 5X



SECTION H-H 5 PL
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

DEO ATTACHED

RELEASED 02-09-05 [illegible]

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
3) WELDING: PER DART QSI 004

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MFG. APPR.		D3391 SHEET 6 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	

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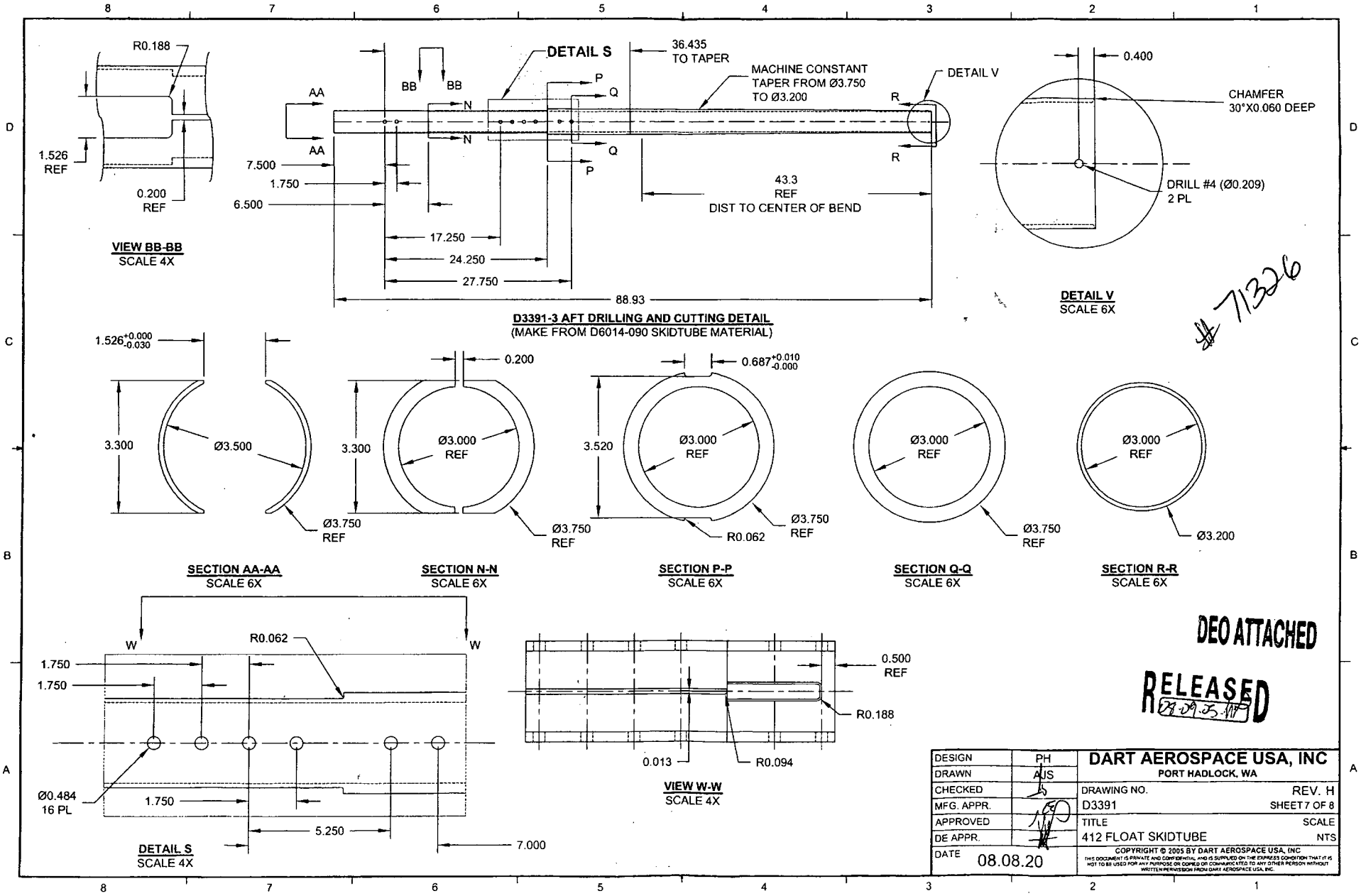
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


R0.188
1.526 REF
0.200 REF
VIEW BB-BB
SCALE 4X
DETAIL S
36.435 TO TAPER
MACHINE CONSTANT TAPER FROM Ø3.750 TO Ø3.200
DETAIL V
AA
BB
N
P
Q
R
7.500
1.750
6.500
17.250
24.250
27.750
88.93
43.3 REF DIST TO CENTER OF BEND
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)
0.400
CHAMFER 30°X0.060 DEEP
DRILL #4 (Ø0.209) 2 PL
DETAIL V
SCALE 6X
1.526 +0.000 -0.030
3.300
Ø3.500
Ø3.750 REF
0.200
Ø3.000 REF
0.687 +0.010 -0.000
3.520
R0.062
Ø3.200
SECTION AA-AA
SCALE 6X
SECTION N-N
SCALE 6X
SECTION P-P
SCALE 6X
SECTION Q-Q
SCALE 6X
SECTION R-R
SCALE 6X
W
R0.062
1.750
Ø0.484 16 PL
5.250
7.000
DETAIL S
SCALE 4X
0.500 REF
R0.188
0.013
R0.094
VIEW W-W
SCALE 4X
DEO ATTACHED
RELEASED
DESIGN PH
DRAWN AJS
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 08.08.20
DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3391
REV. H
SHEET 7 OF 8
TITLE 412 FLOAT SKIDTUBE
SCALE NTS
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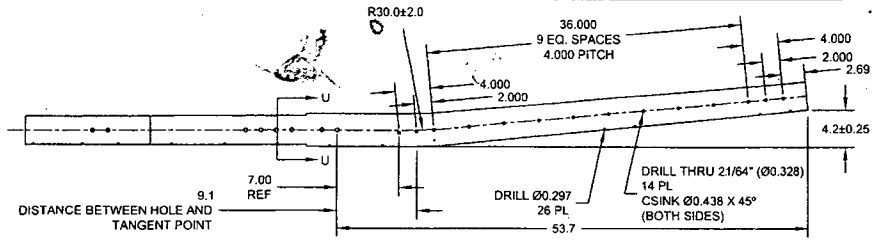
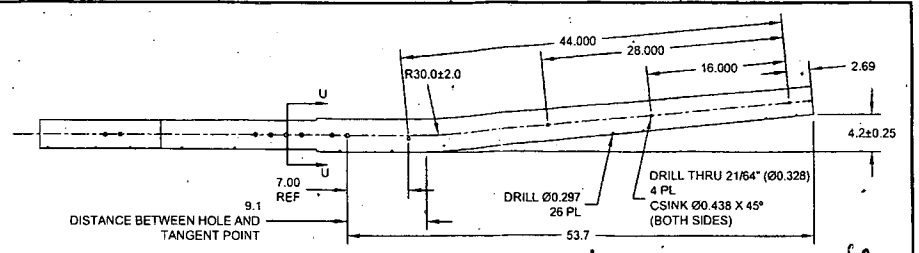
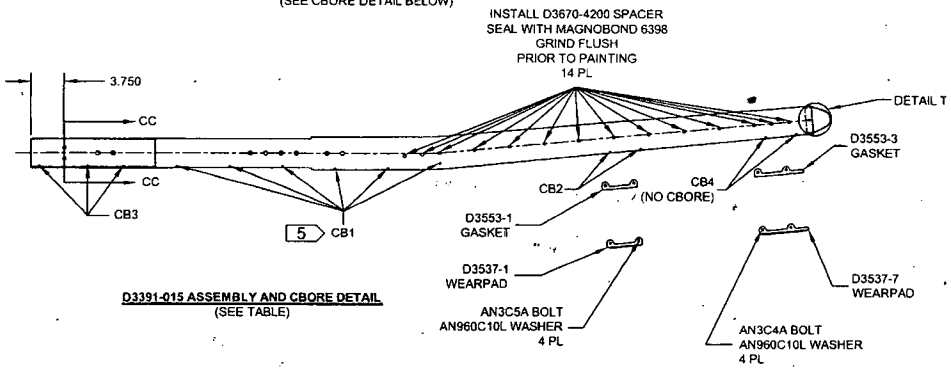


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

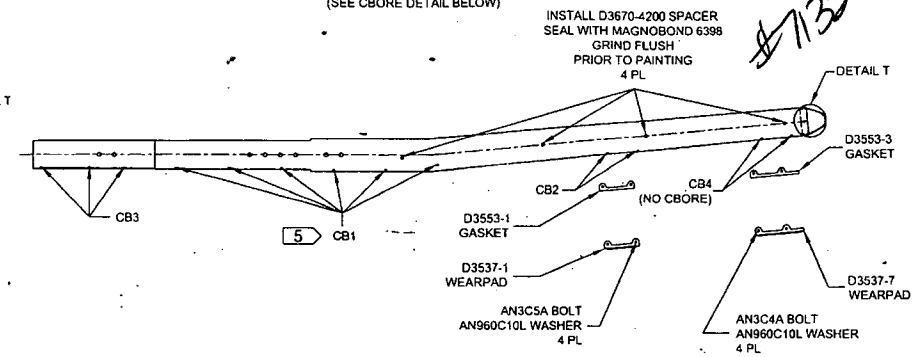


D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

#71326



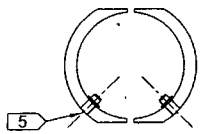
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



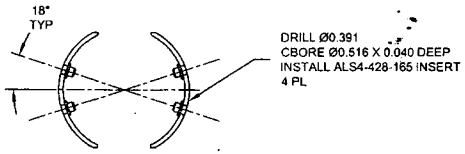
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

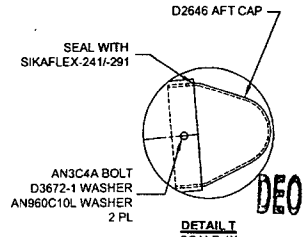
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X



DETAIL T
SCALE 4X

DEO ATTACHED

RELEASED
08.09.05

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
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MFG. APPR.		D3391 SHEET 8 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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DRAWING NO.	TITLE	REV. H	DART AEROSPACE USA, INC	D.E.O. NO.	SHEET NO.	SCALE
D3391	412 FLOAT SKIDTUBE		ENGINEERING ORDER	D3391-H-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30

PURPOSE:
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:
AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

#71326

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE